

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027027**Date Inspected:** 13-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme**Location:** 95 Pineview, Amherst NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Expansion Joint Hinge A**Summary of Items Observed:**

This Inspector, Kevin P Sullivan, along with Ken Riley (QAI) Caltran OSM, arrived at Watson Bowman Acme as requested to inspect in process fabrication of the support plates, deck plates and channel boxes per approved drawings B-24952. Flatness of the top plates were verified by this QAI on the following components; welded channel boxes CA1-2, CA2-1, CA2-2 and CA2-4. The QC was observed as using several tools to verify the flatness which included, a 1830mm (6') Starrett Straight edge, calibrated by Northeast Metrology on 1/16/10 and a 300mm (12") scale calibrated 4/2/11 along with mechanical feeler gauges. The WBA personel and QC technicians used the 1830mm straight edge to lay across the top plates and using the feeler gauges set at 1mm and 2mm checked the flatness of the four (4) channel assemblies. These components were noted as being within the required tolerances as noted in the contract documents.

**Summary of Conversations:**

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and WBA Personell.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

**Inspected By:** Sullivan, Kevin

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:** Foerder, Mike

QA Reviewer